

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009144**Date Inspected:** 20-Sep-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Hiranch Patel, was present during the times noted above for observations relative to the work being performed.

Bay#11

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member is identified as OBG Components. The weld designations reviewed are as follows:

-(ESTL3-4K/K-022, 051)

-(ESTL3-4J/K-004, 005)

-(ESTL3-4I/K-095, 096, 088)

-(ESTL3-4B/K-077, 078)

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel on ESTL3-4B/K-078. During inspection, this QA inspector found one subsurface rejectable indication in base metal 10mm away from weld # ESTL3-4B/K-078. The indication was ground out at approximately 6mm in depth. For further information, please see the attached pictures below.

This QA inspector observed the following work in progress:

Bay#14

SMAW welding of weld joint Seg052\*-047 located on Segment 9BE. Welder is identified as 044779 (4G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

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SMAW welding of weld joint Seg052\*-046 located on Segment 9BE. Welder is identified as 200114 (4G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg052\*-045 located on Segment 9BE. Welder is identified as 069656 (4G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint SSD16-PP074-004 and SSD17-PP075-004 located on Segment 9BE. Welder is identified as 066459 (3G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg54\*-031, 032, 033, 034 located on Segment 9CE. Welder is identified as 055564 (3G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint Seg54\*-023, 024, 025, 026 located on Segment 9CE. Welder is identified as 044774 (3G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

SMAW welding of weld joint Seg54A-001 located on Segment 9CE. Welder is identified as 067609 (4G). ZPMC QC-CWI is identified as Wang Xu. The welding variables recorded by QC appeared to comply with the Applicable WPS.

### Segment 8AW

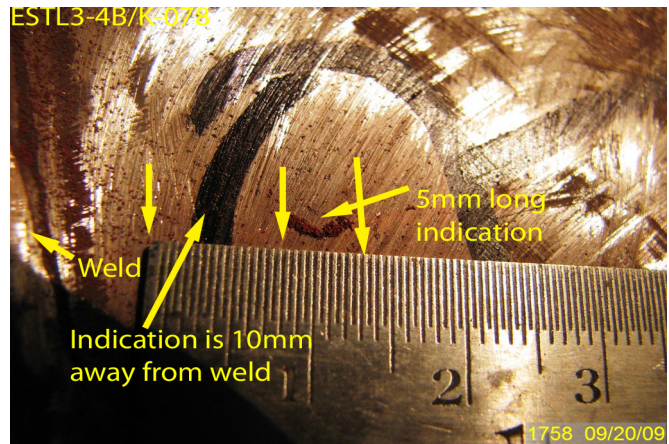
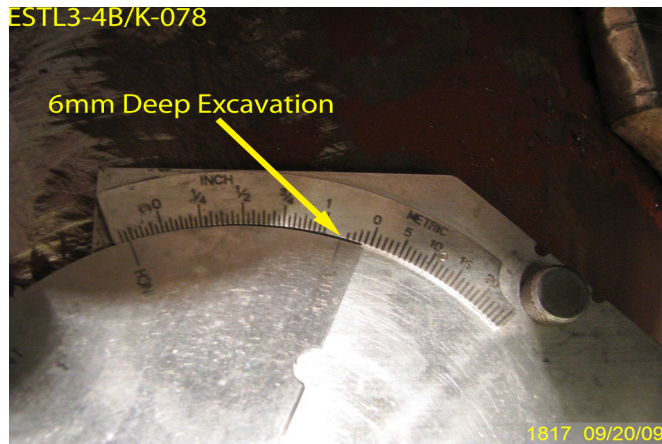
FCAW welding of weld joint SSD009A-PP061-007~044 located on Segment 8AW. Welder is identified as 066683 (3F). ZPMC QC-CWI is identified as Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS.

FCAW welding of weld joint LD002-056-012 located on LD002-056. Welder is identified as 051356 (1G). ZPMC QC-CWI is identified as Guo Yuan Ting. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

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Item	Description	WBS	Dwg No.	Status
1				

## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Patel,Hiranch	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer